

Date: Thursday, 20/11/2008 3:34:07 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WEARSHOE
<b>Job Number</b> : 43599	
<b>Estimate Number</b> : 10330	
<b>P.O. Number</b> :	
<b>This Issue</b> : 20/11/2008 <b>S.O. No.</b> :	<b>Part Number</b> : D2746
<b>Prsht Rev.</b> : NC	<b>Drawing Number</b> : D2746 REV C
<b>First Issue</b> : / /	<b>Project Number</b> : N/A
<b>Previous Run</b> : 41737	<b>Drawing Revision</b> : C
	<b>Material</b> :
	<b>Due Date</b> : 20/12/2008 <b>Qty:</b> 12 <b>Um:</b> Each
<b>Written By</b> :	
<b>Checked &amp; Approved By</b> : <u>JLD 08.11.21</u>	
<b>Comment</b> :	
: Est Rev: D 02.10.24 Re-format KJ	
: Est Rev: E 06-03-21 as Per Rev C JLM	
: Est Rev: F 06-06-12 Now On Waterjet JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025 SHEET
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**Comment:** Qty.: 0.4263 sf(s)/Unit Total: 5.1156 sf(s)  
 1010/1025/A21/6aA .040" SHEET  
 (M1010S20GA)  
 Batch: 109289 1B 8-12-10

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D2746  
 Dwg Rev: C  
 Prog Rev: C 1B 8-12-10  
 2-Deburr if necessary 1B 8-12-10



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 28/12/10 (13)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Deburr if necessary.

1/1

Done at step #2.2

S 28/12/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 20/11/2008 3:34:07 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 43599

Part Number: D2746

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D2746 using Jigs DT8261 and DT8326

2-Form joggle on Punch as per Dwg D2746 using Jig DT8158 Identify as D2746

JB 08/12/15

(13)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/15

(13)

8.0

POWDER COATING

POWDER COATING



M 109648



(1.3X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1 = 50  
3200F  
2 = 20

m-1 08/12/15

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 08/12/15

(13)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST496

SS 08/12/16

(13)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/16

Job Completion



u 08/12/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

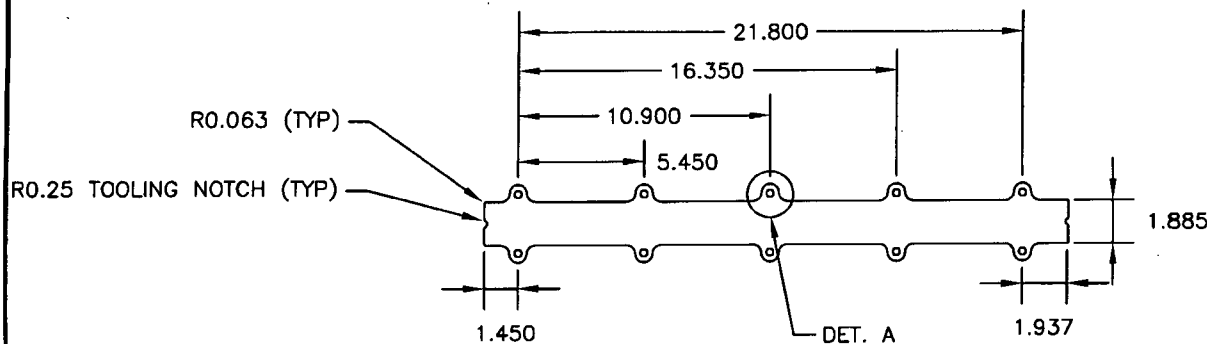


**DART**

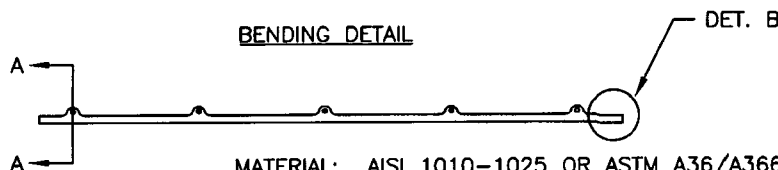
**RELEASED**  
06-02-07

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
P1	P1	DRAWING NO.	REV. C
CHECKED	APPROVED	D2746	SHEET 1 OF 1
DATE	TITLE	WEARSHOE	SCALE
06.01.12			1:8
A	98.04.16	NEW ISSUE	
B	98.08.18	RE-DESIGN	
C	06.01.12	ENLARGE HOLES TO IMPROVE FIT	

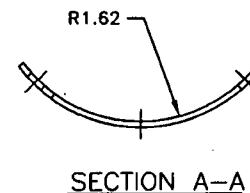
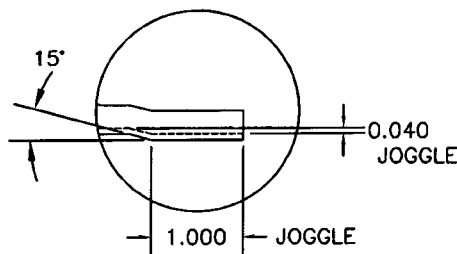
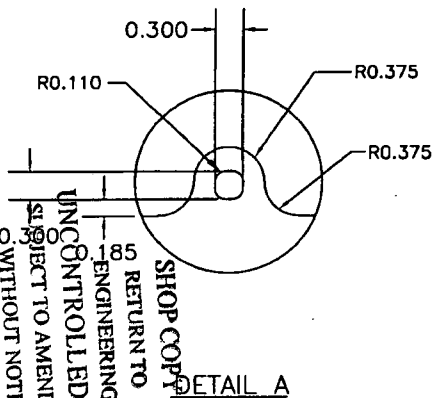
FLAT PATTERN



BENDING DETAIL



MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)



NO. 13591  
WORK ORDER  
NOTES

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL, 20 GAUGE (0.040 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) THIS PART CAN BE MADE BY MODIFYING D2656-21